

Work Order ID 65302

January 11, 2011 9:21:04 AM

Page 1

Item ID: D2432

Accept

Setup Start

Revision ID:

Stop

Item Name: 206 (24") Bearpaw

Start Date: 1/18/11 Start Qty: 20.00

Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: MP Date: 11-01-10 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B 11-1-19

(20)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

on 11/02/01

B 11-1-19

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

on 11/02/01

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		A.A 11/02/02		21	0		
151 Packaging Packaging	Identify as per dwg & Stock Location: <u>P1P</u> Memo <u>65302 206</u> <u>1 to stock</u>	0.00 0.00							
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/02/03 (21)

11/02/03

MF
11-02-03

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Picklist Print

January 11, 2011 9:21:03 AM

Page 1

Work Order ID: 65302

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

312.5794

3.7

74

77.7



UHMW 1" Black



1B11-1-19

Location

Loc Qty

Loc Code

MAT

312.5794

114624

5.2734

115325

15.506

115955

38.8

116281

13

✓116554

240

116554

24

28
16
16
/0

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DART AEROSPACE LTD		Work Order: 65302
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.060x45°	—	Ueln	ML-7
B	5.500	+/-0.030	5.502	—	"	"
C	0.200	+/-0.030	.194	—	"	"
D	0.25 x 45°	+/-0.030	.232x45°	—	"	"
E	R0.250	+/-0.030	R.250	—	Rad-gage	REF
F	0.250	+/-0.010	.248	—	Ueln	ML-7
G	0.625	+/-0.030	.633	—	"	"
H	0.375	+/-0.010	.382	—	"	"
I	0.950	+0.030/0.010	.954	—	"	"
J	19.000	+/-0.030	19.000	—	M-type	ML-2
K	3.14	+/-0.030	3.125	—	Ueln	ML-7
L	3.28	+/-0.030	3.300	—	"	"
M	Ø0.260	+0.005/-0.000	Ø.264	—	"	"
N	Ø0.93	+/-0.030	.932	—	"	"
O	0.30	+0.030/-0.000	.319	—	"	"
P	23.750	+/-0.030	23.750	—	M-type	ML-2
Q	7.375	+/-0.030	7.375	—	"	"
R	4.250	+/-0.010	4.250	—	"	"
S	2.000	+/-0.030	2.000	—	"	"
T	9.000	+/-0.010	9.000	—	"	"
U	9.000	+/-0.010	9.000	—	"	"
V	0.375	+/-0.010	.377	—	Ueln	ML-7

Measured by: <i>AME</i>	Audited by: <i>LA</i>	Prototype Approval: N/A
Date: 11/02/01	Date: 11/02/02	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>

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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. F
SHEET 1 OF 2

DESIGN	DRAWN BY	DRAWING NO.	SCALE
KE	KE	D2432	1:6
CHECKED	APPROVED	TITLE	
MM		BEARPAW	
DATE			
98.05.12			

RELEASED
98.06.17 KE

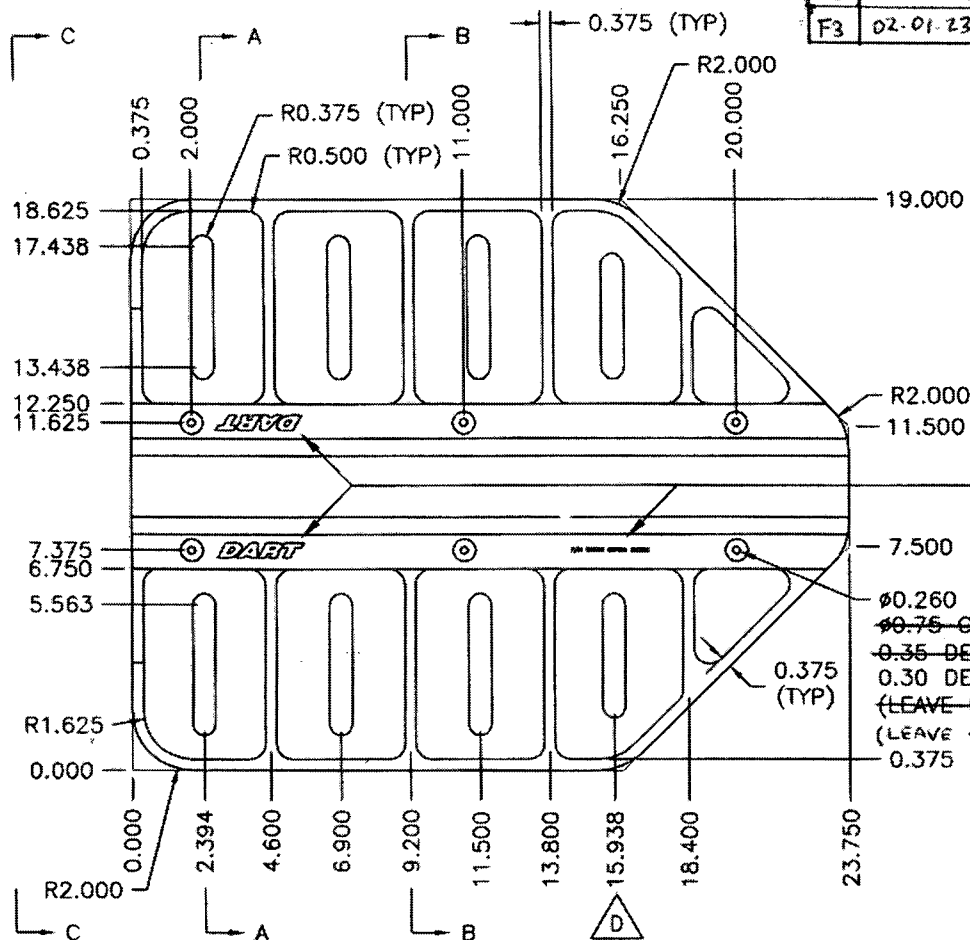
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

F2
F1
F
F1

EFFECTIVE DEOS
9143

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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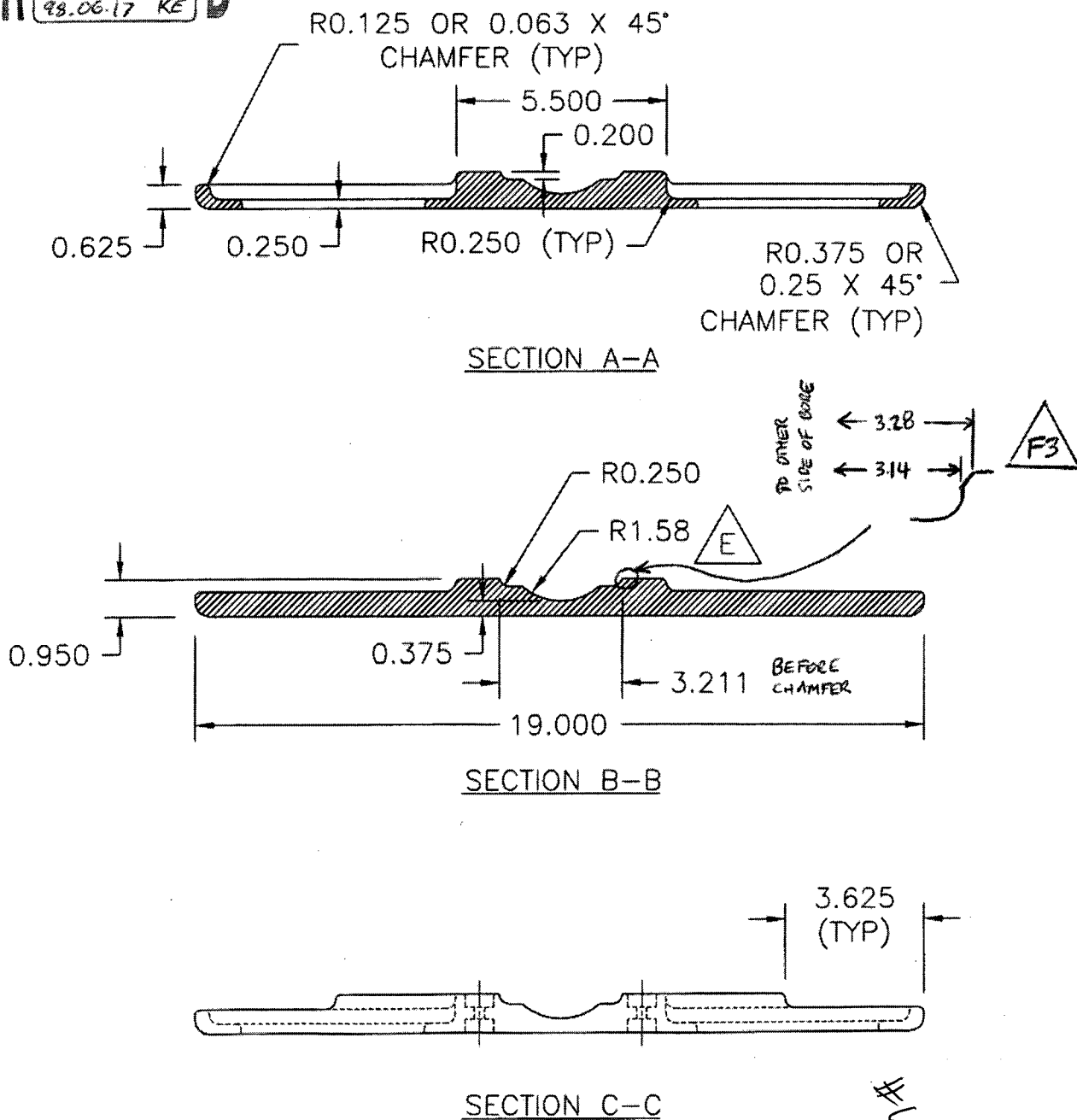
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



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